

Work Order ID 81774

Blue
81774

Page 1

March-19-12 1:18:24 PM

Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2650 | F |

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Debur Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod M120164

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Debur and Blow out all chips from inside the tube

> CF 12-3-21

{ BE 12-03-22
→ CF 12-3-28

{ SAD 12-03-29

→ CF 12-3-28

→ SAD 12-03-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

125

QC7-Inspect Chemical Conversion Coat

0.00

125

QC

Memo

0.00

Quality Control

SAD 12-04-02

①

SAD 12-04-02

①

12-4-2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence.ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

130

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting

Start Date: 12-4-2 Time: 9:45

Finish Date: 12-04-03 Time: 1:00

A/RSikaflex-291 120813

Sikaflex expiry date: 12-08-13

SAD 12-04-02

CF 12-4-2

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 0 BR 12/04/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81774***81774***

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Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/RAluminum Rod *m120164* *BE 12/04/03*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

4- Install nut plate as per dwg

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

*S. 12/04/09**3/CC 12/4/9*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 190 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank. | | | | | | | | |
| 195 | Spray Painting per QSI005 4.2 | 0.00 | | | | | | | |
| *195* | | | | | | | | | |
| SprayPaint | Memo | 0.00 | | | | | | | |
| Spray Painting | PRIME B <u>117319</u> DELFLEET BLUE B <u>121149</u> CLEAR DELFLEET B <u>118093</u> | | | | | | | | |

5/2/12/12/12

1 12-4-17

12 - 4 - 17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

205

QC14- Inspect Spray Paint

0.00

205

QC

Memo

0.00

Quality Control

(1)

1d. 04.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00

220

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 11119412

Sikaflex expiry date: 12/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291 11119413

Sikaflex expiry date: 12/10

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 11120955

1 x 1 11120955 12/10 12/10

PTO =>

| W/O: 8774 | | WORK ORDER CHANGES | | | | | |
|-----------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 12/04/25 | 220 | Assemble with (x2) MS 270 391-08 / <u>M121011</u> As per detail "E" drawing | MM | 12/04/25 | x2 | | |
| 12/04/25 | 220 | Assemble with (x2) NAS 114900 3325 / <u>M120644</u> As per detail "E" drawing | MM | 12/04/25 | x2 | | |

Part No: D206-642-341 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 81774

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Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 19/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 18/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 240 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 250 | Packaging | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-642-341 | | | | | | | | |
| | Location: <u>PPP 81787</u> | | | | | | | | |
| | PPP Rev: <u>81787</u> | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81774***81774***

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Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00


260

QC

Memo

0.00

Quality Control

12/5/16 
ME
12-05-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

March-19-12 1:18:29 PM

Page 1

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: H05.10.11 Added D3429-1 per CHG004KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

AN960JD416 ~~NAS1149D04631~~ Purchased

No

Each 14.0000

1

AN960.ID416
Washer

**

1112#255 (x1) 12/10/12

Location

Loc Qty

Loc Code

ST351

14

116289

14

CCR264SS3-3 Purchased

No

Each 603.0000

2

CCR264SS3-3
Cherry Rivet

**

1cc 12/14/12

Location

Loc Qty

Loc Code

ST331

603

113973

2

117849

125

119017

476

CR3212-4-03 Purchased

No

Each 1,460.000

2

CR3212-4-03
Cherry Rivet

**

1cc 12/14/12

Location

Loc Qty

Loc Code

FP002

470

114859

470

ST331

990

110139

2

119017

988

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

March-19-12 1:18:29 PM

Page 2

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

28.0000

D2620

Skidtube, 206 Skidtube

**

1

CF12-3-21

Location

Loc Qty

Loc Code

LG

28

77999

1

79543

2

79544

2

79545

2

81365

11

81366

10

D2647

Manufactured No

Each

47.0000

D2647

Cap

**

1

BE12-03-22

Location

Loc Qty

Loc Code

LG002

47

75482

47

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

March-19-12 1:18:29 PM

Page 3

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

1,431.000

19

D2649

Cross Bolt Spacer

**

BE 12/04/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 974 | |
| 77574 | 2 | |
| 79502 | 403 | |
| 79503 | 399 | |
| 79504 | 14 | |
| 79565 | 156 | |
| LG001 | 457 | |
| 65317 | 1 | |
| 68224 | 2 | |
| 68507 | 11 | |
| 71355 | 2 | |
| 72704 | 2 | |
| 72841 | 11 | |
| 73390 | 8 | |
| 73857 | 21 | |
| 73858 | 53 | |
| 73859 | 4 | |
| 73860 | 4 | |
| 78020 | 6 | |
| 78583 | 2 | |
| 79566 | 330 | |

D2654-5

Manufactured No

Each

14.0000

D2654-5

Web

**

1
①

CF 12.4.02

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 14 | |
| 80057 | 8 | |
| 81326 | 6 | |

B82129 - pulled 82127

#81914

Wrong bath number pulled on

March-19-12 1:18:29 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist-Print

March-19-12 1:18:29 PM

Page 4

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each 148.0000

D2680-041

Nut Plate

**

1
100 12/4/19

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

32

76790

32

Each

1,594.000

56

MS27039C1-08

Purchased

No

MS27039C1-08

SCREW

**

52 12/04/25

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST292

1500

120308

1000

121068

500

ST293

93

116373

3

118077

14

119309

76

220

Each

4,213.000

54

54

ALS4-1032-130

Purchased

No

ALS4-1032-130

Insert

**

52 12/04/25

Location

Loc Qty

Loc Code

ST280

283

119084

116

120671

167

ST281

3930

120807

1930

120837

2000

Y34

March-19-12 1:18:29 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

March-19-12 1:18:29 PM

81774

D206-642-341

Required Date: 18/05/2012

Required Qty: 1.00

| | | | | |
|-----|------|--------|----|----|
| 220 | Each | 0.0000 | 54 | 54 |
|-----|------|--------|----|----|

** 11121255 (x54) Mulberry

| | | | |
|------------|----------------------|-----------|----|
| AN960JD10L | <u>NAS1149D0332J</u> | Purchased | No |
|------------|----------------------|-----------|----|

| | | | | |
|-----|------|--------|---|---|
| 220 | Each | 0.0000 | 2 | 2 |
|-----|------|--------|---|---|

** M170644 (x2) ME 12/04/25

| | | |
|-------|--------------|----|
| D2646 | Manufactured | No |
|-------|--------------|----|

| | | | | |
|-----|------|----------|---|---|
| 220 | Each | 125.0000 | 1 | 1 |
|-----|------|----------|---|---|

** 41 12/04/25

Aft Cap

Loc Code

125

5

5

1

2

1

2

26

33

50

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 81774

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

81774

D206-642-341

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

551.0000

14

14

D2651-1

Plug

**

12/04/25

Location

Loc Qty

Loc Code

FP001

827

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

188

79234

278

FP-A

-276

77559

1

78124

23

814

D2651-3

Manufactured No

220

Each

1,888.000

14

14

D2651-3

O-Ring

**

12/04/25

Location

Loc Qty

Loc Code

FP001

16

61962

12

73828

4

FP-A

1872

78126

1872

814

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist-Print

March-19-12 1:18:30 PM

Page 7

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|--------------------|
| D3535-11 | Manufactured | No | 220 | Each | 21.0000 | 1 | 1 |
| *D3535-11* | | | | | | ** | <u>ju 12/04/25</u> |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 21 | |
| 71284 | 6 | |
| 79058 | 15 | <u>X1</u> |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|--------------------|
| D3535-23 | Manufactured | No | 220 | Each | 35.0000 | 1 | 1 |
| *D3535-23* | | | | | | ** | <u>ju 12/04/25</u> |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 35 | |
| 73314 | 6 | |
| 74508 | 11 | |
| 80330 | 18 | <u>X1</u> |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|--------------------|
| D3535-35 | Manufactured | No | 220 | Each | 32.0000 | 1 | 1 |
| *D3535-35* | | | | | | ** | <u>ju 12/04/25</u> |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 32 | |
| 67598 | 1 | <u>B81358</u> |
| 70815 | 1 | <u>XL</u> |
| 78873 | 13 | |
| 79849 | 1 | |
| 80332 | 16 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

March-19-12 1:18:30 PM

Page 8

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | |
|------------|--------------|----|-----|------|---------|---|---|--|
| D3536-11 | Manufactured | No | 220 | Each | 28.0000 | 1 | 1 | |
| ** | | | | | | | | |
| *D3536-11* | H 12/04/25 | | | | | | | |
| Gasket | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 28 | B82152 |
| 46649 | 1 | |
| 46715 | 4 | |
| 65574 | 1 | |
| 80006 | 22 | |

| | | | | | | | | |
|------------|--------------|----|-----|------|---------|---|---|--|
| D3536-23 | Manufactured | No | 220 | Each | 42.0000 | 1 | 1 | |
| ** | | | | | | | | |
| *D3536-23* | M 12/04/25 | | | | | | | |
| Gasket | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 42 | |
| 43406 | 1 | |
| 73312 | 3 | |
| 74510 | 12 | |
| 80334 | 26 | |

| | | | | | | | | |
|------------|--------------|----|-----|------|---------|---|---|--|
| D3536-35 | Manufactured | No | 220 | Each | 32.0000 | 1 | 1 | |
| ** | | | | | | | | |
| *D3536-35* | M 12/04/25 | | | | | | | |
| Gasket | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 32 | |
| 74511 | 5 | |
| 80335 | 27 | |

B82065

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist-Print

March-19-12 1:18:30 PM

Page 9

Work Order ID: 81774

81774

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

220

Each

165.0000

6

6

D3537-1

Wearpad

**

u 12/04/25

Location

Loc Qty

Loc Code

FP001

104

B83254

x 6

79833

50

79835

54

FP002

61

69817

5

79834

14

80336

42

D3537-3 Manufactured No

220

Each

14.0000

1

1

D3537-3

Wearpad

**

u 12/04/25

Location

Loc Qty

Loc Code

FP002

14

B78836

x 1

74500

9

76986

5

MS27039-4-06 Purchased No

220

Each

185.0000

1

1

MS27039-4-06

Screw

**

u 12/04/25

Location

Loc Qty

Loc Code

ST292

185

119075

185

x 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81774 MLCJ
12/03/19

RELEASED
08-07-23-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL .20.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|------------|--|--|--------------|
| F | DRAWING UPDATED TO CURRENT STANDARDS, SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | RMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW, INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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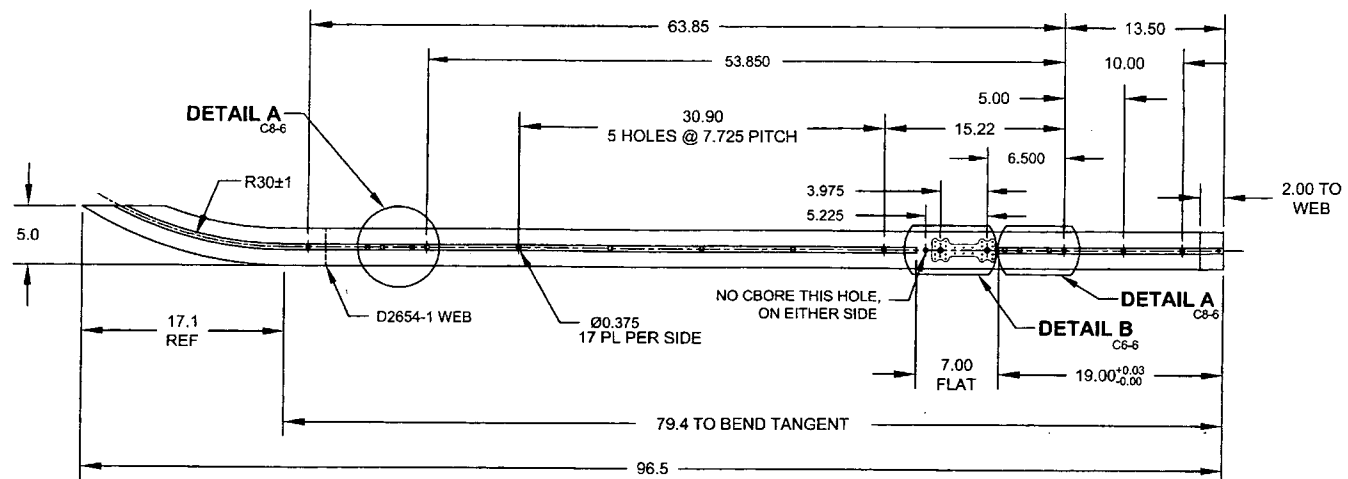
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

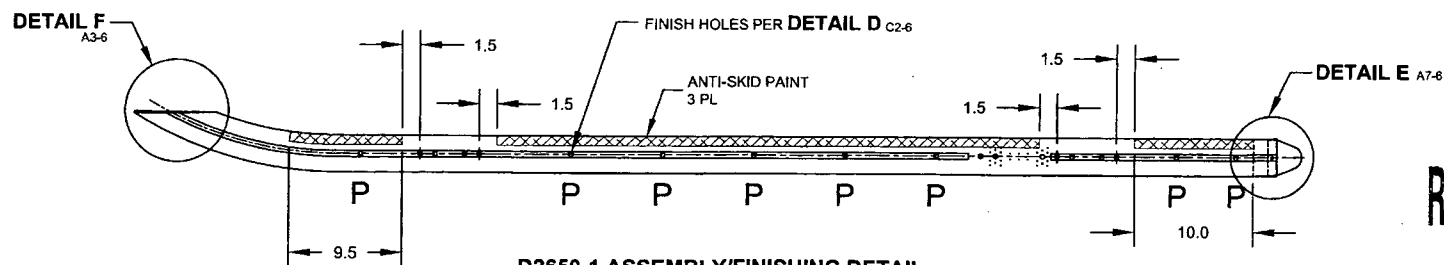
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
82-6722-1/114

| | | | |
|------------|----------|---|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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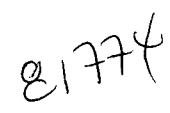
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



DETAIL F
A3-6

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FINISH HOLES PER **DETAIL D**
C2-6

ANTI-SKID PAINT
3 PL

1.5

DETAIL E
A7-6





P P P P P P P P

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12.0

RE

RELEASED
05 09 22 1984

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|------------|---|---|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | AJS | | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D2650 | SHEET 3 OF 6 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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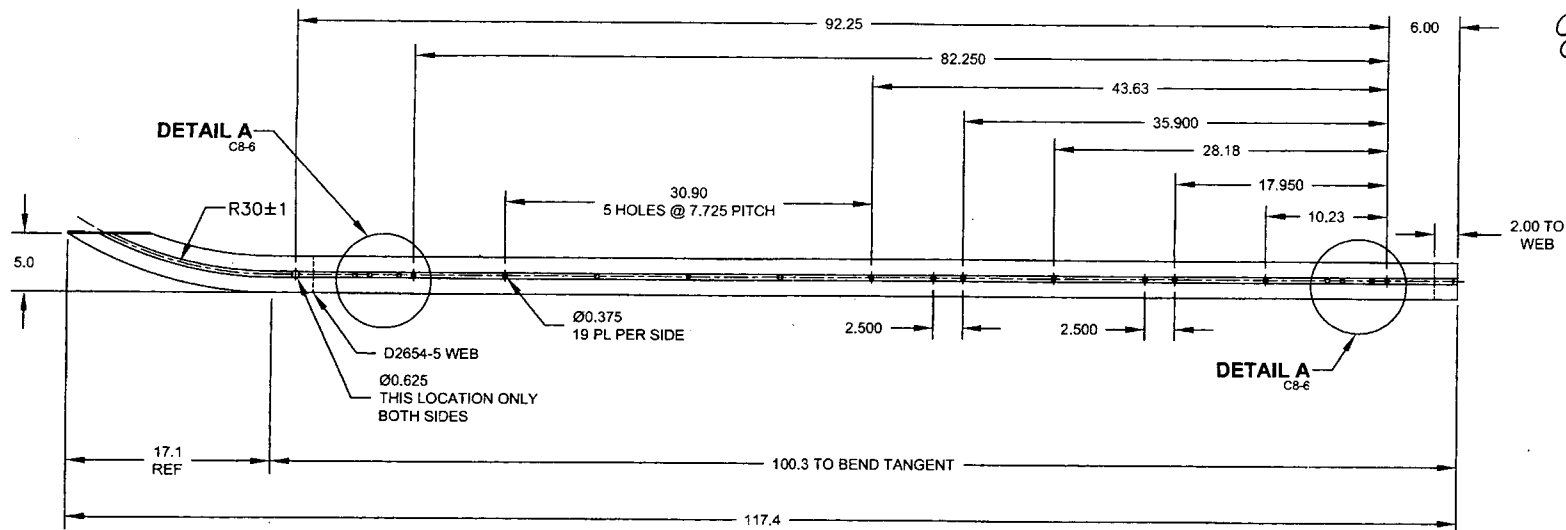
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

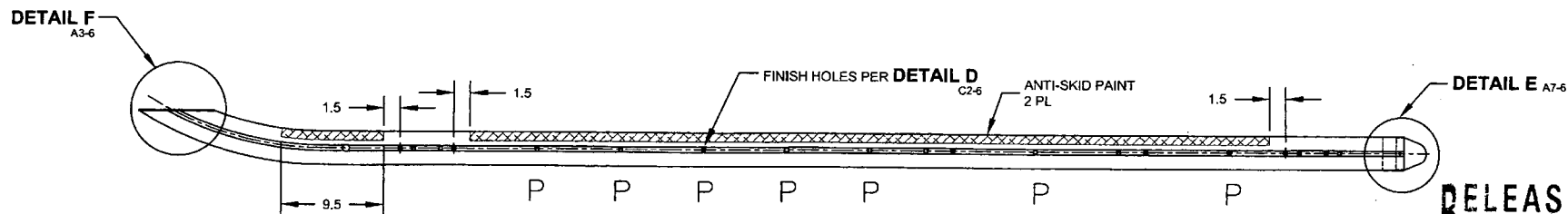
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

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| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>[Signature]</i> | D2650 | SHEET 4 OF 6 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries




| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|------------|---|---|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. # |
| MFG. APPR. |  | D2650 | SHEET 6 OF 6 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | 206/407 SKIDTUBE ASSEMBLIES | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 287

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 796517
Part number: A206-646-341
Description: Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Alum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier David Bush Date of Test Coupon 12-04-03
Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld